

Work Order ID 141481 - 2

Friday, February 05, 2016 8:00:10 AM

141481

Page 1

Item ID: D412-705-017

Accept

Revision ID:

N900040100

Setup Start

NS1

Item Name: NI Gearbox Access Panel

Stop

NS2

Start Date: 1/28/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: MCS Date: FEB 08 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

IIN-D412-705

E

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-705-017

CHG001

MAR 07 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
28
9-89

Work Order ID 141481

Friday, February 05, 2016 8:00:10 AM

141481

Page 2

Item ID: D412-705-017

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Item Name: N1 Gearbox Access Panel

Stop ***NS2***Start Date: 1/28/2016 Start Qty: 3.00 ***3***

Cust Item ID:

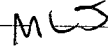
Required Date: 2/3/2016 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
						MAR 07 2016			
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-705-017 Location : FG027	0.00 0.00		fg027					
						MAR 07 2016			
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
						MAR 07 2016			

 MAR 07 2016

Picklist Print

Friday, February 05, 2016 8:00:13 AM

Page 1

Work Order ID: 141481

141481

Parent Item: D412-705-017

D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 1/28/2016

Required Date: 2/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:C Removed Manufacturing 06-08-02 JLM
IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A		Purchased	No			110	Each	282.0000	30	90			

AN3C3A

Bolt

**

Location

Loc Qty

Loc Code

GA
m132930
OVER002
m134055
ST350
m132930
m133990

46
46
75
75
161
86
75

DAS
6
9-89

DAS
28
9-89

D3255-041

D3255-041

Access Panel Assy LH

D3255-042

D3255-042

Access Panel Assembly

Manufactured No

Manufactured No

110 Each 0.0000

110 Each 4.0000

**

**

3

3

FEB 1 8 2016
FEB 25 2016
129990x1
129908x2
DAS 6 9-89
DAS 28 9-89

Location

Loc Qty

Loc Code

ST489
127416

4
4

DAS
6
9-89

DAS
28
9-89

MS20427M3-3

MS20427M3-3

Rivet

Purchased No

110 Each 1,009.0000

**

108

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA
m132256
m133577

1009
11
998

108

Picklist Print

Friday, February 05, 2016 8:00:13 AM

Page 2

Work Order ID: 141481

141481

Parent Item: D412-705-017

D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 1/28/2016

Required Date: 2/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS21060-L3K

Purchased

No

110

Each

185.0000

18

54

2

MS21060-L3K

Nut Plate

DAS

6

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

45

m127836

7

m131467

1

m132256

37

ST300

121

131677

2

m133922

119

ST302

19

m131187

19

MS9321-09

Purchased

No

110

Each

402.0000

30

90

2

MS9321-09

Washer

DAS

6

9-89

Location

Loc Qty

Loc Code

ST260a

250

m133990

250

ST267

50

m133932

50

ST273

102

131677

102

DAS

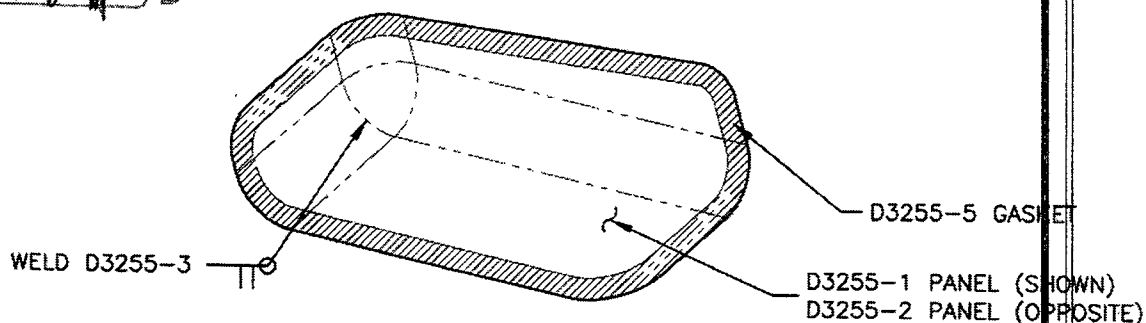
28

9-89

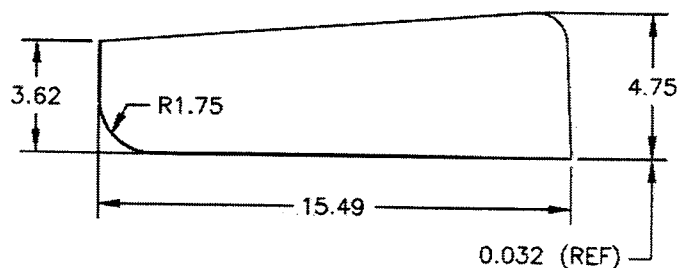
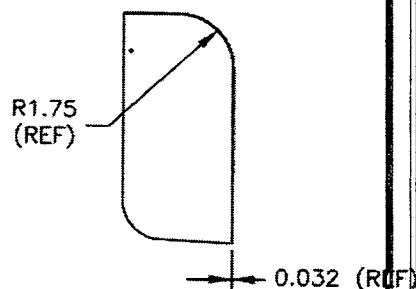
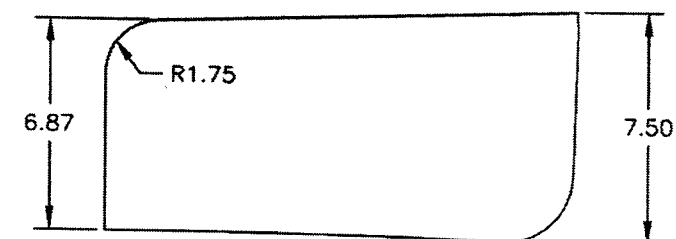


DESIGN P#	DRAWN BY P#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED	00.098

RELEASED
05-01-18



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

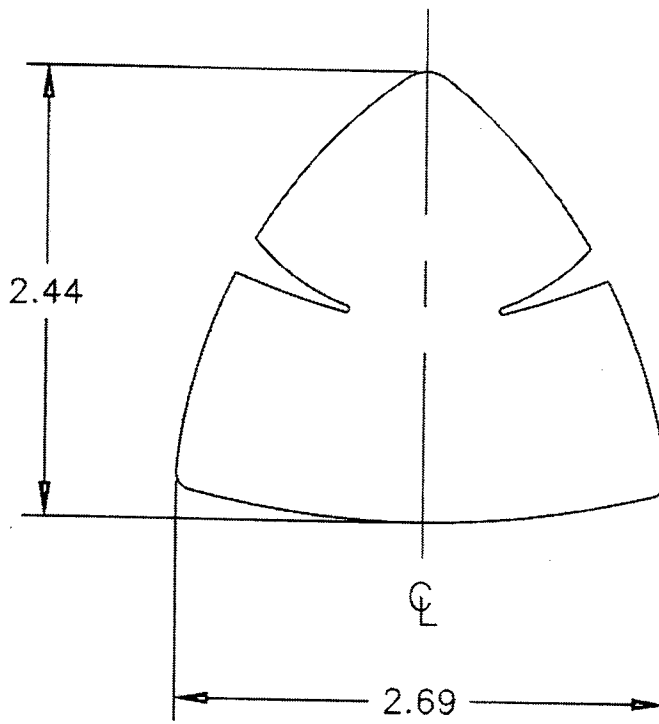
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4/	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.08 [Signature]



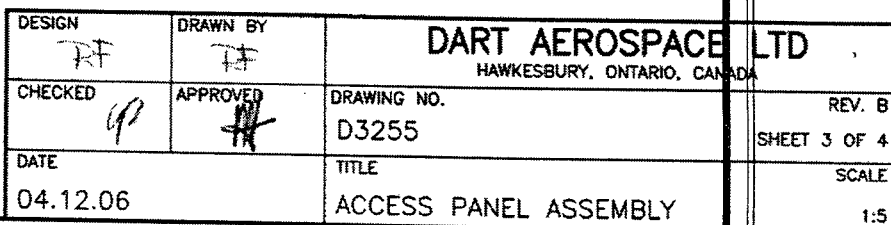
D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

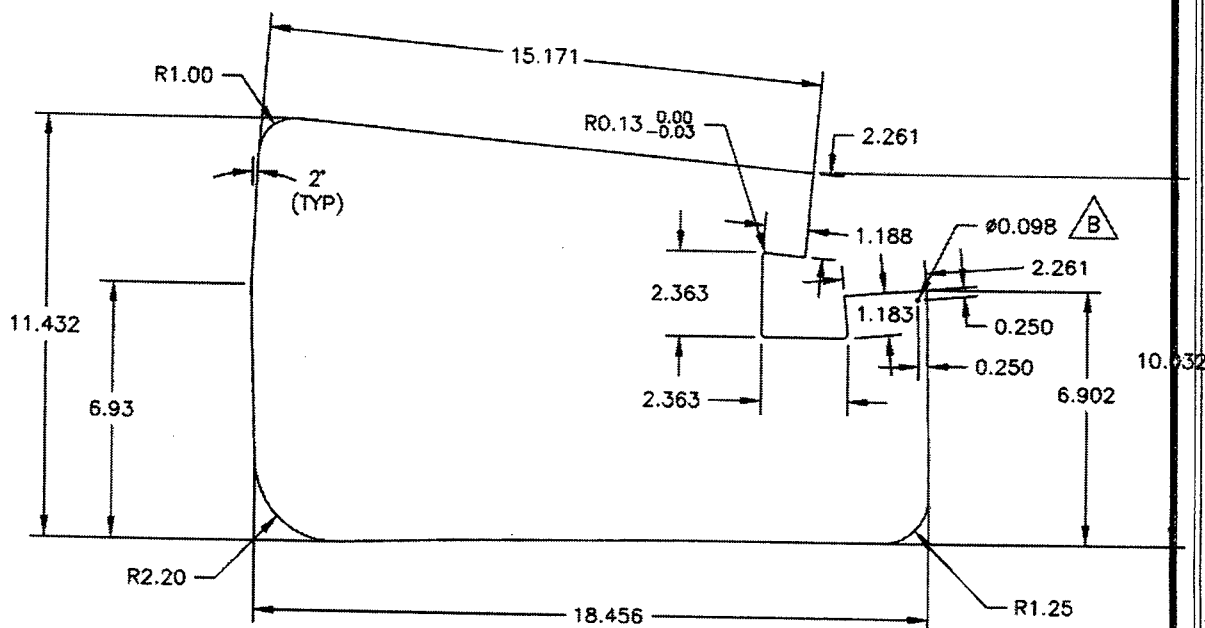
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

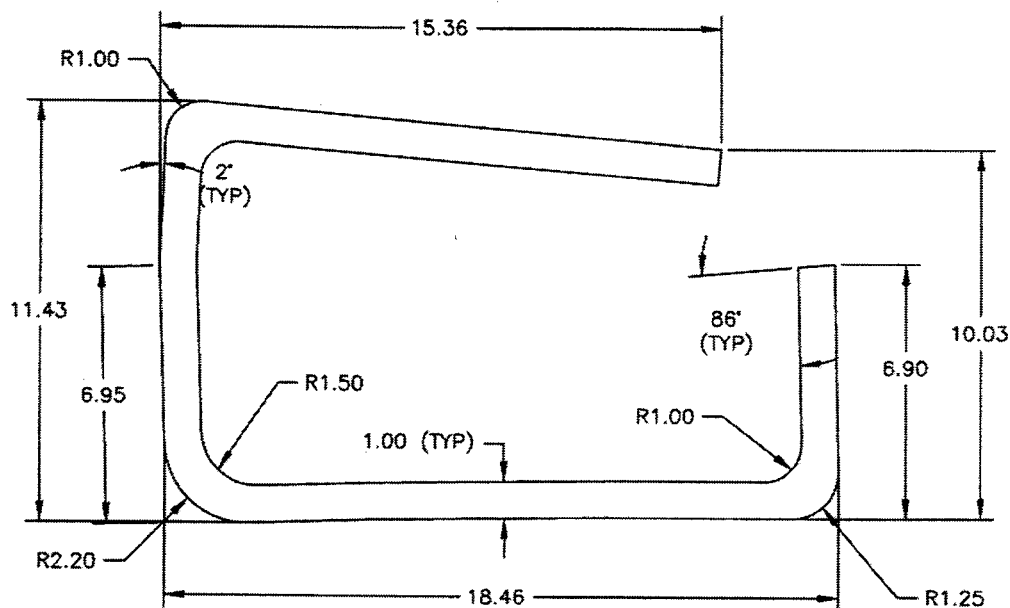
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18 JF



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty (-017)	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			(13)				D3255-041	ACCESS PANEL ASSEMBLY, LH
		1					D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
							D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	(30)		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
	16	44	(36)		12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
	8	22	(18)		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	(30)		6		MS9321-09	WASHER

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Revision: E

Date: 13.10.07